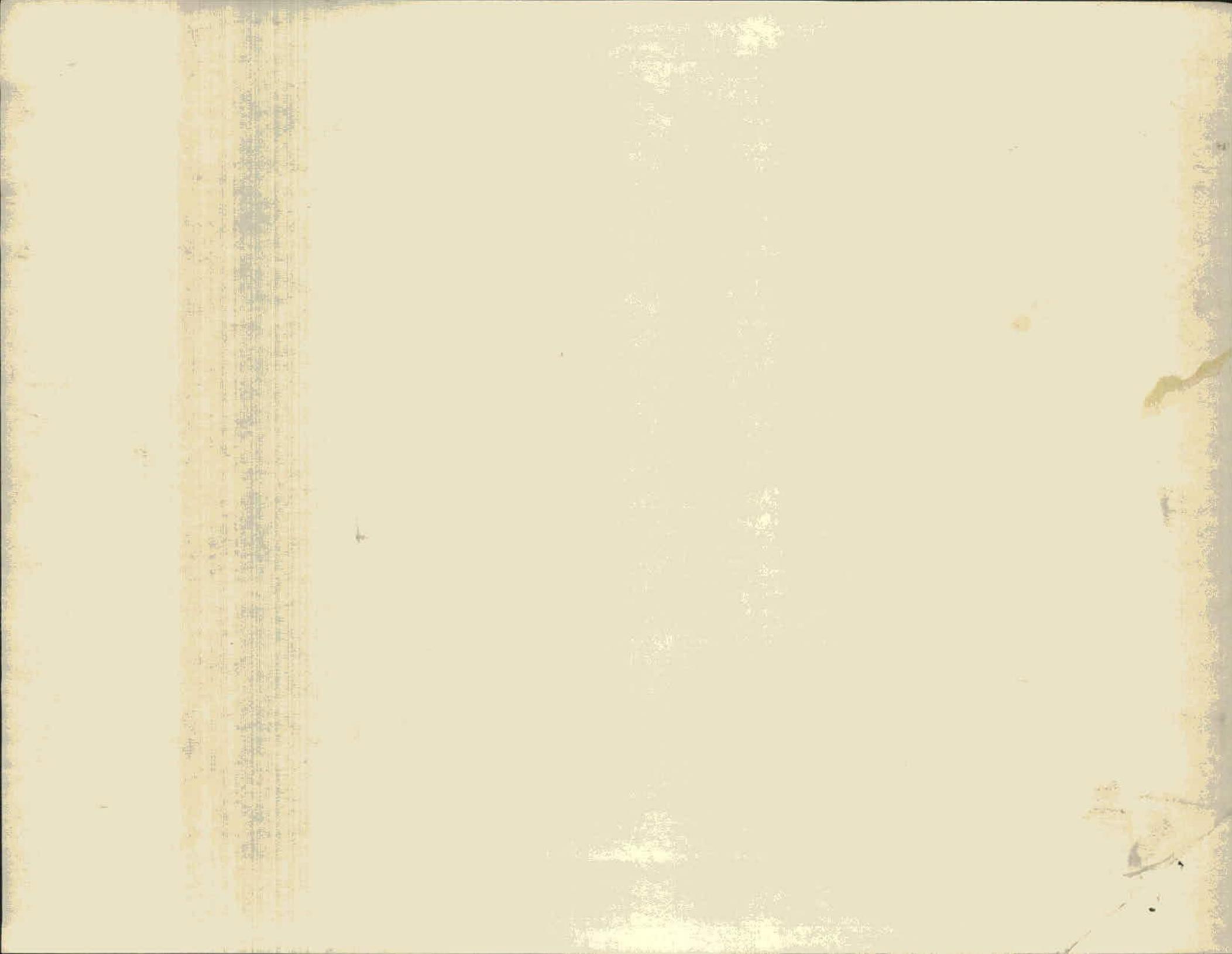


Date: Thursday, 07/08/2008 4:23:20 PM
User: Julie Léocaca

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 41067		
Estimate Number	: 12578		
P.O. Number	:	Part Number	: D3560041
This Issue	: 07/08/2008	S.O. No.	: D3560 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: D
Previous Run	: 40299	Material	:
Written By	:	Due Date	: 26/08/2008
Checked & Approved By	: NO 088.38	Qty:	40
Comment	Est Rev:A est rev B Est Rev:C	New Issue 07.05.24 EC ECN 987 07.10.09 EC verified by: DD ECN1048 07-12-18 DD verified by: EC	Um: Each
<i>Split</i>			
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00	
			
Comment: Qty.: 1.4648 f(s)/Unit Total : 14.6475 f(s)	6061-T6 Bar 0.50" x 5.00"	<i>28/08/2023</i>	
Batch: <u>A108294</u>			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW	Cut blanks 16.750" long	<i>28/08/2023</i>	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1		<i>28/08/2023</i>	
1- Mill as per Folio FA693 Rev: <u>A</u> & Dwg D3560 Rev: <u>D</u>			
2-C'sink 0.196" hole on manual mill as per dwg D3560			
3-Deburr per dwg D3560		<i>JL 08/08/25</i>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>JL 08/08/25</i>	



Date: Thursday, 07/08/2008 4:23:20 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 41067		Part Number: D3560041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		 SP 08.08.29 (12)
6.0	D35921	Plate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) PLATE Batch: B35331		SP 08.08.29 (ix)
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Weld assembly as per dwg D3560		
STEP: 1- clean material (buff bracket and bottom of arm with blue pad) SP 2- set up bracket and arm on jig SP 3- preheat bracket and arm with torch SP 4- clean before welding with brush SP 5- set up machine to 135 amps SP 6- weld across bottom and top ends SP 7- reheat with torch (65 deg C) SP 8- on one side weld from bottom to top half way SP 9- same for other side (half way) SP 10- from half way point weld the rest of the first side (ease off pedal near end) SP 11- same for remaining side (ease off pedal near end) SP SP 08.08.29 (1A)		
8.0	QC5	INSPECT WORK TO CURRENT STEP S.08.08.29 (1)
Comment: INSPECT WORK TO CURRENT STEP		AD 08.08.29 (1)
9.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		AD 08.08.29 (1)



Date: Thursday, 07/08/2008 4:23:20 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 41067		Part Number: D3560041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
10.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		08/08/29 (X7)
11.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08-09-02 X 1
12.0	D2808 	Bushing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Spacer batch: B37113		08/08/29/11
13.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Press bushing in D3560 arm per dwg D3562		08/08/29/11 (Q)
14.0	QC5 	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		08/08/29/11 (Q)
15.0	PACKAGING 1 	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 152		08/08/29/11 (Q)
16.0	QC21 	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		08/09/15 (D)
Job Completion 		MR 08-09-15



DART AEROSPACE LTD	Work Order:	41067
Description: Arm	Part Number:	D3560-1
Inspection Dwg: D3560	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

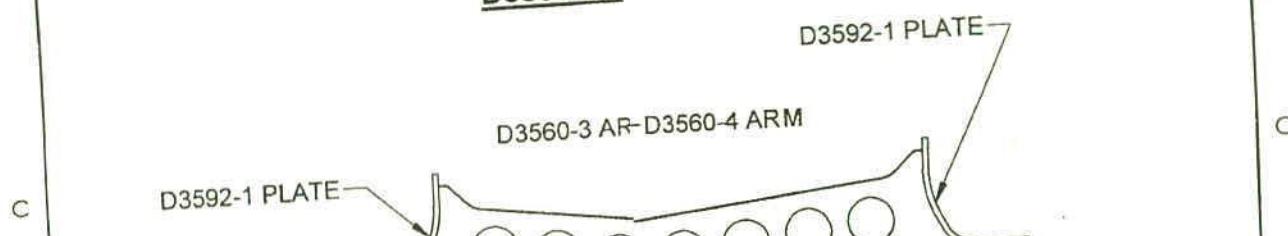
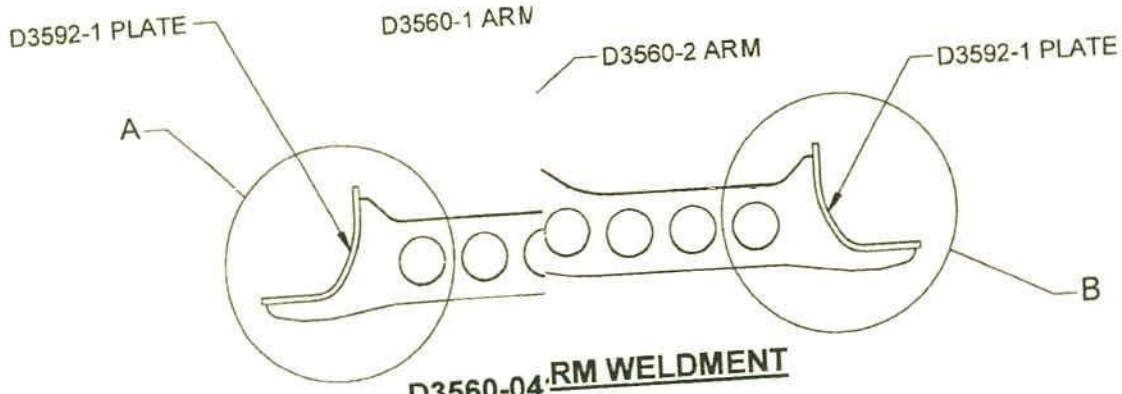
X First Article Prototype

Measured by:	JL	Audited by:	SS	Prototype Approval:	N/A
Date:	08/08/25	Date:	08/08/25	Date:	N/A

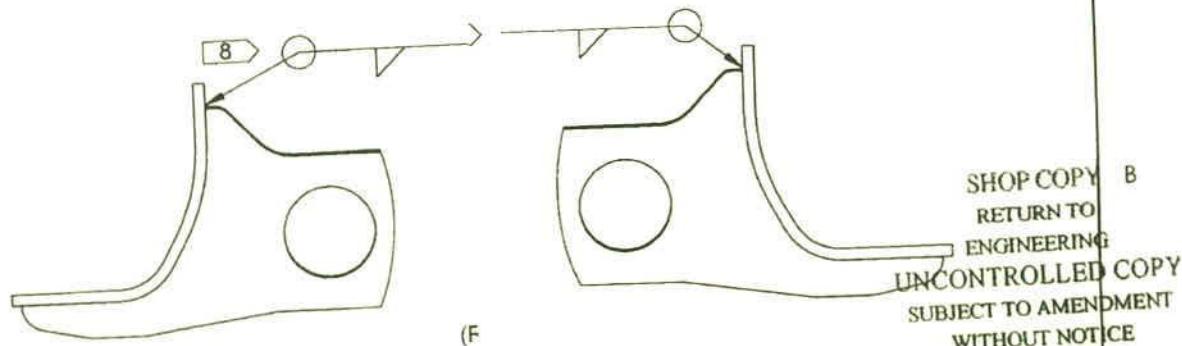
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A	07.01.17	New Issue	P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B		KJ/JLM	
C	08.07.24	Dwg Rev updated		KJ/DD	MM



RELEASED
07.12.14



D3560-043 A ARM WELDMENT



**DETAIL A
SCALE 1 : 2**

**DETAIL B
SCALE 1 : 2**

FIT NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
COAT	CP	07.06.19
MENT, ADD POCKETS	CP	07.01.15
	CP	06.09.25
DESCRIPTION	BY	DATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015"
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

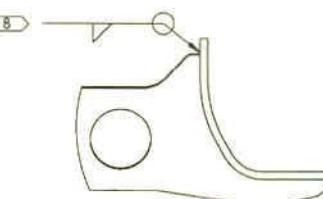
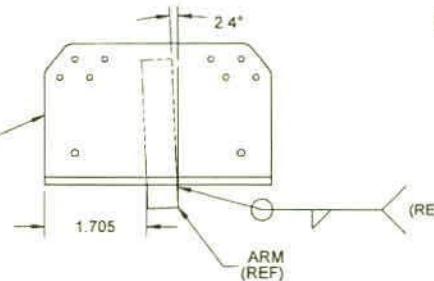
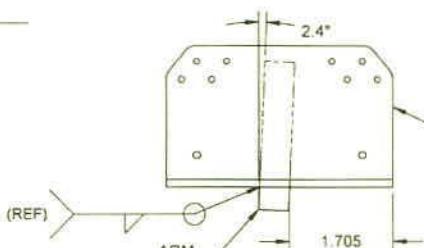
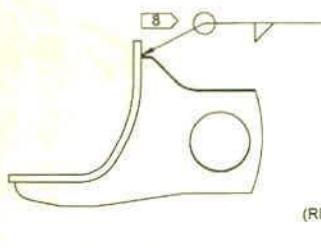
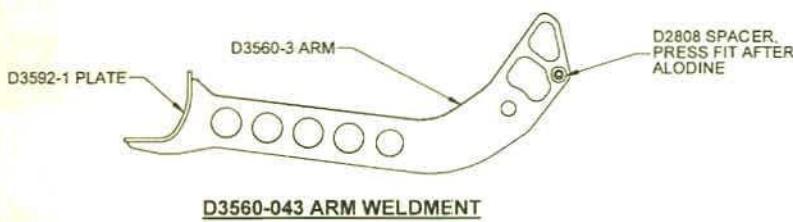
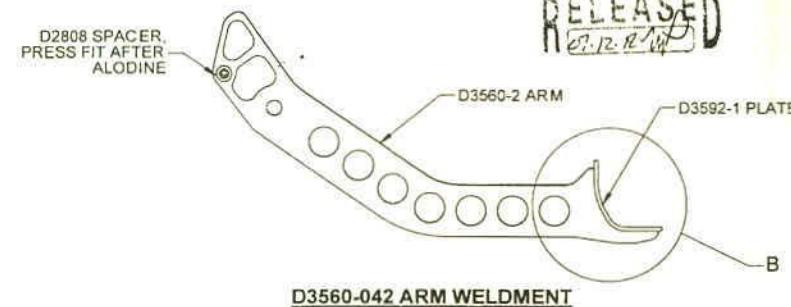
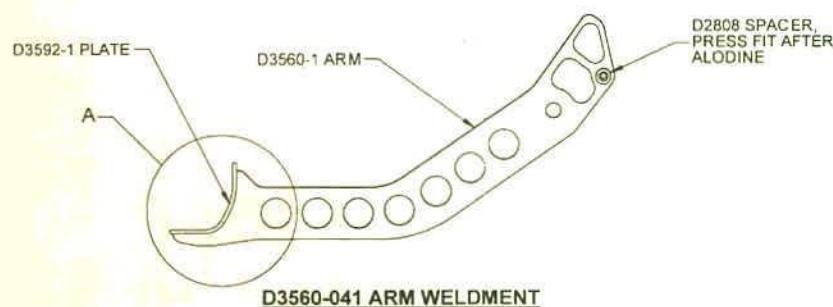
DRAWING NO.	REV. D
D3560	SHEET 1 OF 5
TITLE	SCALE
ARM WELDMENT	1:4

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HAWKESBURY, ONTARIO, CANADA

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07.12.12.14



DETAIL A
SCALE 1:2

PARTS LIST

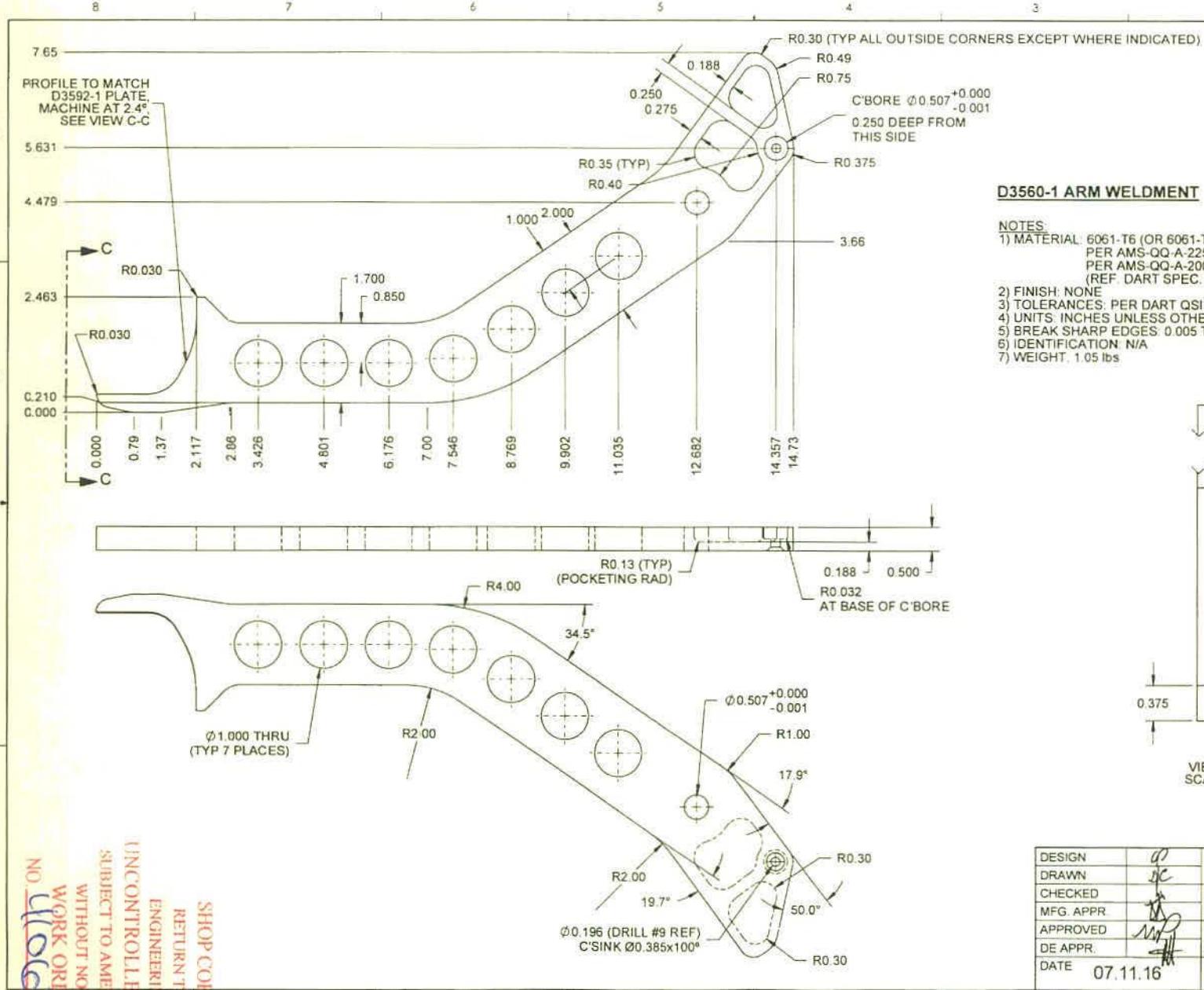
QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
1	1	1	1	D3560-4	ARM
1				D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN	100	DART AEROSPACE LTD	
DRAWN	JLC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SD	DRAWING NO.	REV. D
MFG APPR.	FJF	D3560	SHEET 1 OF 5
APPROVED	JK	TITLE	SCALE
DE APPR.	JK	ARM WELDMENT	1:4
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NOTES:
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES .005 TO .015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.23 lbs (TYP)
 8) WELDING: PER DART QSI 004

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1. *Antennae*
2. *Abdomen*
3. *Legs*
4. *Wings*
5. *Head*
6. *Thorax*
7. *Antennal bases*
8. *Abdominal segments*
9. *Leg bases*
10. *Wing bases*
11. *Head and thorax*
12. *Abdomen and thorax*
13. *Abdomen and head*
14. *Abdomen and legs*
15. *Abdomen and wings*
16. *Abdomen and antennae*



D3560-1 ARM WELDMENT

NOTES

NOTES
1) MATERIAL 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. PART SPEC. MC6617SR 500)

2) FINISH: NONE

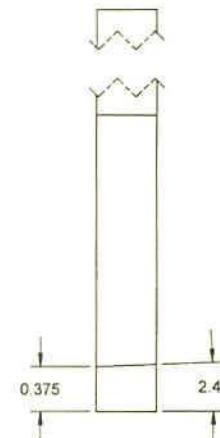
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS INCHES UNLESS OTHERWISE NOTED
SPEAKERS 6.500 TO 6.615 MAX

5) BREAK SHARP EDGES 0.005 TO 0.010
6) IDENTIFICATION N/A

6) IDENTIFICATION
7) WEIGHT 1.05 lbs

7) WEIGHT, 1.05 LB

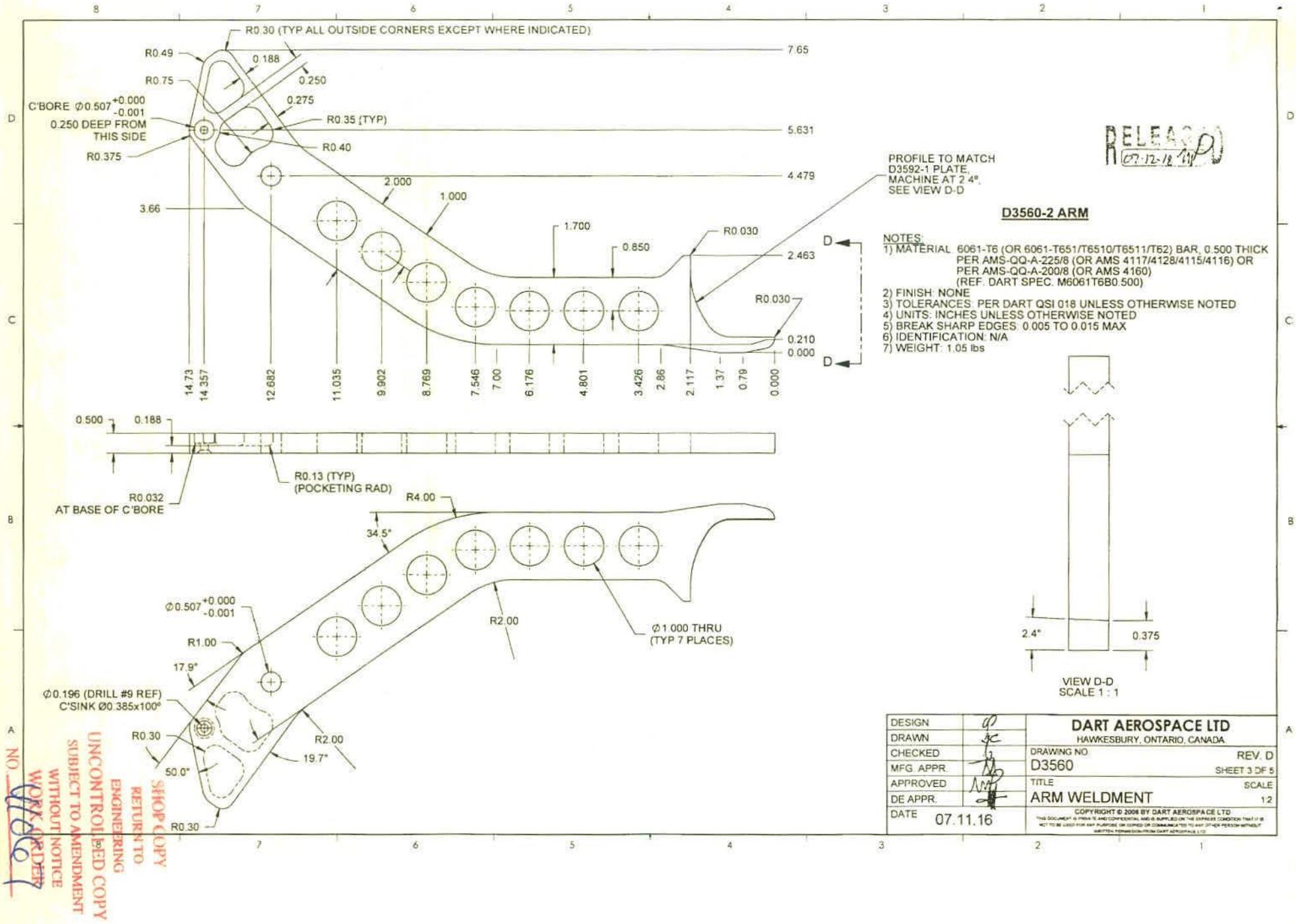


VIEW C-C
SCALE 1

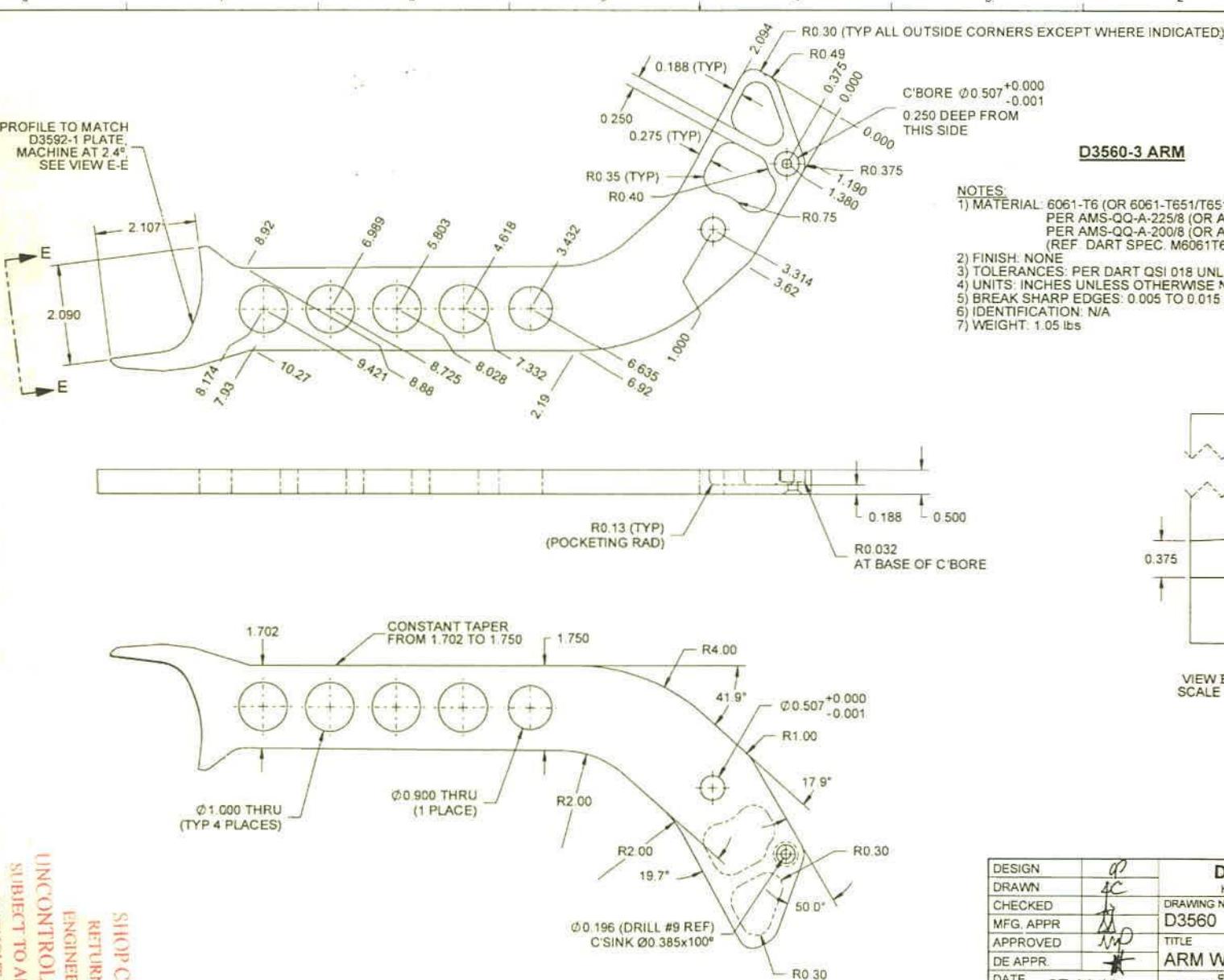
RELEASER
07/28/17

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DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>TA</i>	DRAWING NO.	REV. D	
MFG. APPR	<i>TA</i>	D3560	SHEET 2 OF 5	
APPROVED	<i>SDP</i>	TITLE	SCALE	
DE APPR.	<i>SDP</i>	ARM WELDMENT	1:2	
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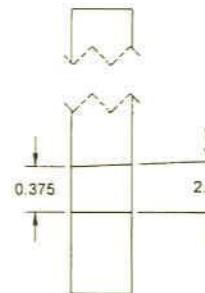




NOTES

- NOTES**

 - 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs

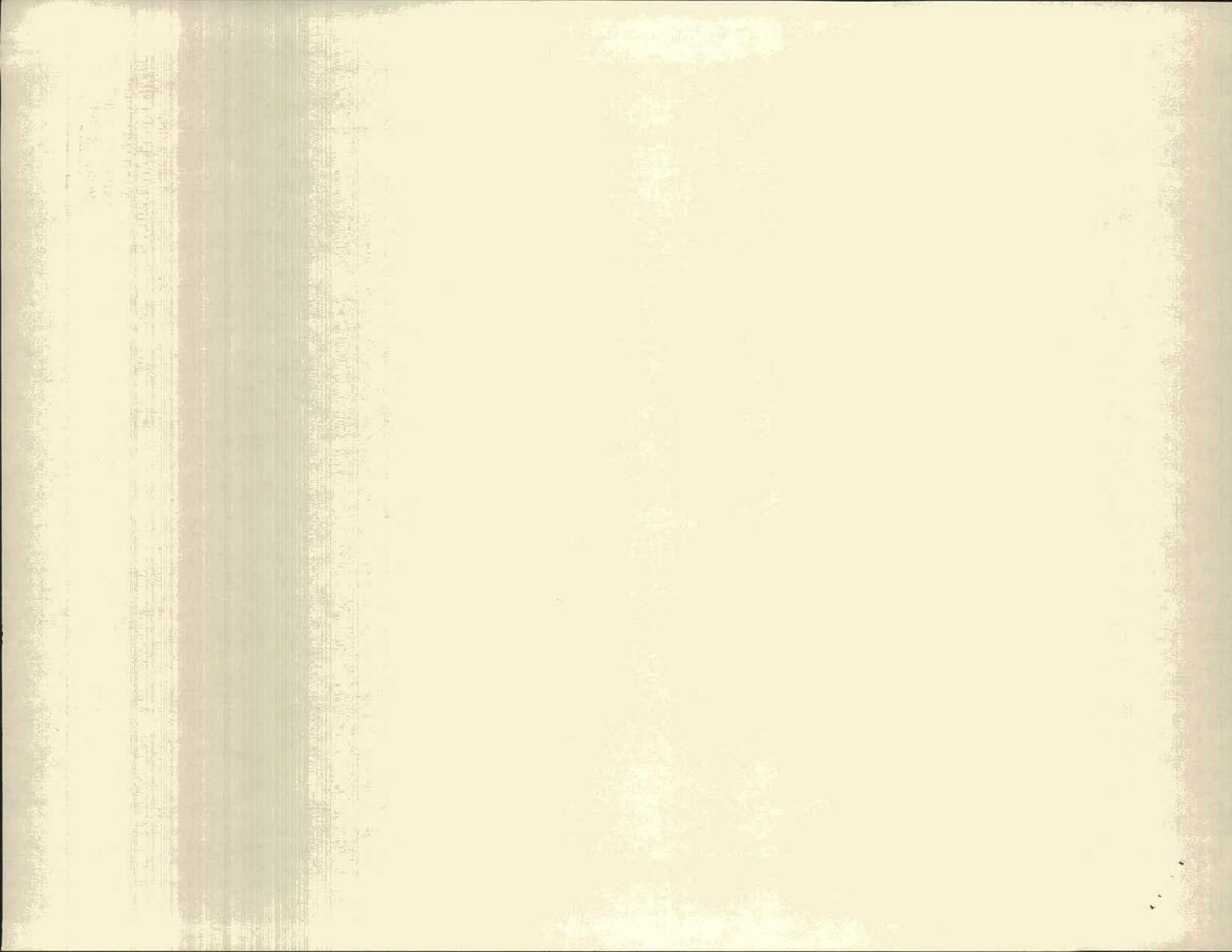


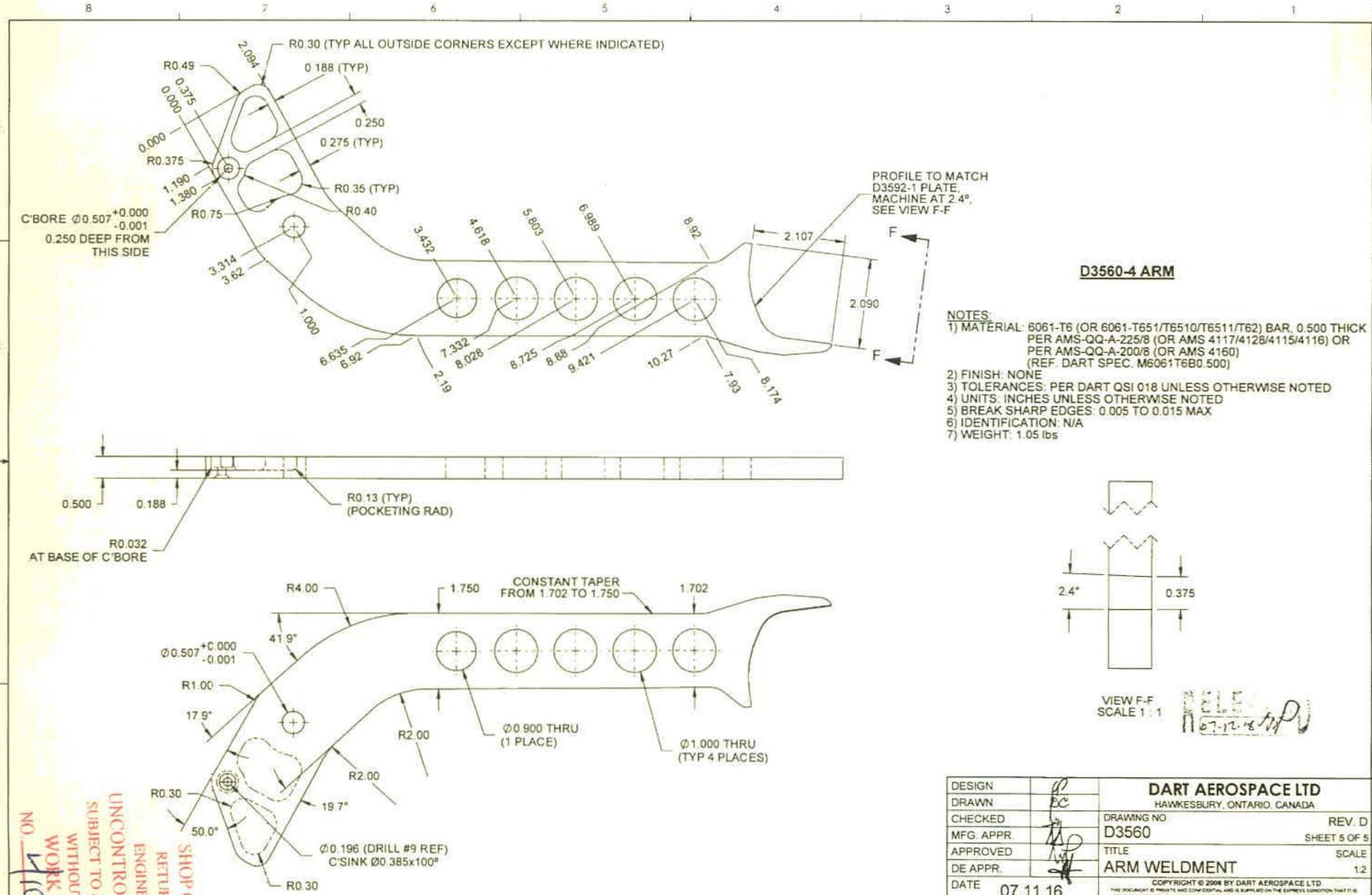
VIEW E-E
SCALE 1 : 1

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MFG. APPR	<i>BB</i>	D3560	SHEET 4 OF 5
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>#</i>	ARM WELDMENT	
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